

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 82.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025415**Date Inspected:** 25-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Westmont Industries**Location:** Santa Fe Springs, CA**CWI Name:** Ruben Dominguez**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006 L & R**Component:** Maintenance Travelers**Summary of Items Observed:**

On this date, Caltrans Quality Assurance Inspector (QA) Sherri Brannon is present at the Westmont Industries (WMI) jobsite in Santa Fe Springs, California for the purpose of observing fabrication and QC functions for the SAS Superstructure, Bid Item #99, Maintenance Traveler and Bid Item #100, Maintenance Traveler (Bike Path).

E2/E3 Bike Path Traveler

This QA Inspector made random shop observations and observed no fit-up performed on the E2/E3 Bike Path Traveler Assemblies on this date.

SAS-WB Traveler – Lower Truss Frame Assembly

Welding Completed on the SAS-WB Traveler – Lower Truss Frame Assembly on Thursday 5-12-11. Quality Control Mr. Dominguez informed QA Inspector that Smith Emery did complete visual inspection and waiting on WMI to weld and grind on some area's found by visual inspection. Grinding not completed on this date.

E2/E3-WB Traveler

This QA Inspector randomly observed WMI production personnel Mr. Richard Fuentes WID #3201 and one helper, performing layout, fitting and tack welding activities at various locations for the E2/E3-WB Traveler Assemblies. This QA Inspector observed Mr. Fuentes performing the FCAW in all positions randomly throughout the shift.

This QA Inspector observed WMI production welder Mr. Charles Newton (WID # 3200) continuing to perform Flux Core Arc Welding (FCAW) activities on the E2/E3-WB Traveler Assemblies. This QA Inspector observed

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

Mr. Newton performing the FCAW in all positions randomly throughout the shift.

SAS-WB Traveler - Fixed Stair Section

This QA Inspector randomly observed WMI production personnel Mr. Cesar Canales WID #3195 and helper Mr. Jesus Rayas WID#3197, performing layout, fitting and tack welding activities at various locations for the SAS-WB Traveler Assemblies. This QA Inspector observed Mr. Canales performing the FCAW in all positions randomly throughout the shift.

Elevating Platforms

This QA Inspector made random shop observations and observed no fit-up performed on the Elevating Platforms on this date.

This QA Inspector randomly observed that Smith Emery, CWI, QC Inspector Mr. Ruben Dominguez was present, during the above mentioned welding and fitting activities. During random observation, this QA Inspector observed that the applicable WPS's and copies of the shop drawings, appeared to be located near each work station, where the above mentioned welding and fitting activities were being performed. This QA Inspector randomly verified that the consumable material, utilized during the welding appeared to be in compliance with the applicable WPS and that the above mentioned welders were currently qualified for the applicable process and position of welding. This QA Inspector randomly observed QC Inspector Mr. Dominguez verifying the in-process welding parameters, including voltage, amperage, pre-heat and travel speed and the parameters appeared to be in compliance to the applicable WPS.

This QA Inspector observed that the activities mentioned above, appeared to be in compliance with the contract requirements and this QA Inspector observed no non-conforming issues, on this date.

RPI Coating (Blast and Paint)

QA Inspector was informed by RPI Coating Quality Control (QC) Representative Mr. Miguel Nunez that RPI will be abrasive blasting and applying the Sherman Williams Zinc Clad II prime coat to the Trolley Links that were repaired by WMI earlier this week. Mr. Nunez also, stated that RPI will applying a Sherman Williams DTM Wash Primer over the prime coating to six (6) of the trolley links to seal the prime coating, wait approximately 2 hours or more and then apply the final top coat. Mr. Nunez also, stated that he will be performing final coating tests on a few trolley links to see if the prime coating is continuing to out gassing. Mr. Nunez stated the RPI Coating and Sherman Williams representatives will be on-site later in the afternoon.

After abrasive blasting was completed, QA Inspector then observed QC Mr. Miguel Nunez performing what appeared to be random surface profile checks on the abrasive blasted base metal surfaces. This QA Inspector observed Mr. Nunez utilizing what appeared to be Testex Press-O-Film and a micrometer to perform the testing. Initially, this QA Inspector observed Mr. Nunez applying the film to the blasted surface then utilizes one end of a pen to perform rubbing activities on the clear portion of the test strip. This QA Inspector then observed Mr. Nunez utilize a micrometer to measure the surface profile on the clear film part of the strip, in which the rubbing was performed. Mr. Nunez explained to this QA Inspector that the initial setting on the micrometer was set at 2mils over, due to the thickness of the X-Coarse Press-O-Film paper. During observation, this QA Inspector observed that the readings appeared to be 3.4 mils, and 3.5 mils. This QA Inspector noted surface profiles appear to with contract documents. Contract documents require a surface profile of 1.5 mils, (40 um) - 3.4mils (86um). This QA

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

Inspector observed QC performing soluble salt test at one (1) location. Mr. Nunez informed QA Inspector that RPI would not have time to apply the prime coating the trolley links abrasive blasted today due final coating testing stated above.

Later in the morning QA Inspection observed RPI Coating applying the Sherman Williams DTM Wash Primer to six (6) of the trolley links. QA Inspector observed no out gassing from the DTM Wash Prime.

Later in the afternoon QA met with Sherman Williams Representative Mr. Eric Anderson, Sherman Williams Technical Representative Mr. Carlos Gutierrez and RPI Coating Representative Mr. Gary McDonald and Mr. Carlos Torres. Mr. Torres informed QA Inspector that RPI is going to be performing various tests on the trolley links to try and determine the cause of the out gassing after applying final Polysiloxane Coating.

Final Coating Test performed by RPI Coating

RPI Coating applied the Sherman Williams Polysiloxane XLE-80 Epoxy Siloxane using different methods; Final coating test are as follows:

Test #1

3 test pieces with the DTM Wash Primer - Final coat – results – no gassing occurred.

Test #2

2 test pieces - 1st - light mist coat, waited 15 minutes 2nd final coat – results – light out gassing occurred.

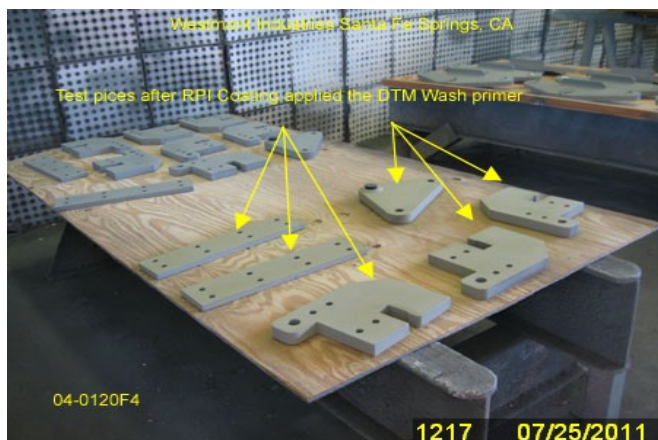
Test #3

3 test pieces - 1st - light mist coat, waited 1 hour, 2nd – final coat – results – gassing occurred.

Test #4

3 test pieces - 1st - light mist coat only. RPI did not complete testing.

After testing was completed RPI Coating Representative Mr. Gary McDonald and Mr. Carlos Torres informed QA Inspector Brannon that RPI Coating and Sherman Williams will discuss the outcome of today's tests and possibly submit an Request For Information (RFI) add the DTM Wash Prime Coat. QA Inspector informed Caltrans Representatives SMR Mr. Nicolai Hvass of the above information on this date.



WELDING INSPECTION REPORT

(Continued Page 4 of 4)



Summary of Conversations:

QA Inspector informed Caltrans Representative SMR Mr. Nicolai Hvass of the above information on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By: Brannon, Sherri

Quality Assurance Inspector

Reviewed By: Lanz, Joe

QA Reviewer